

Work Order ID 120381

120381

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Wednesday, June 04, 2014 3:03:32 PM

Item ID: D412-711-101 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Replacement Vertical Reference Window

Start Date: 6/04/14 Start Qty: 1.00 *1*

Required Date: 6/04/14 Req'd Qty: 1.00 *1*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MLS Date: 14-06-06 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D412-711-101	B								
100	Document Control	0.00							
100									
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefiles and create labels for PPP D412-711-101 Change 002								
110	HAND FINISHING THERMOFORMING	0.00							
110									
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	Set up Machine as per folio FTA 077 and D711W program using mould DT9640								
120	HAND FINISHING THERMOFORMING	0.00							
120									
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	Cut Blanks to 37.5" by 43"								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge		
☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other		

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 Revision ID: Stop *NS2*
 Item Name: Replacement Vertical Reference Window
 Start Date: 6/04/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 6/04/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	THERMOFORMING MACHINE	0.00							DAS 07 9-89
130	Memo	0.00				x/			14/09/17
Thermoform	Thermoform as per Dwg. D412-711-101 using DT 9640 and Folio FTA 077								
Thermoforming Machine	Dwg. Rev. <u>B</u>								
	Folio Rev. <u>A</u>								
	Visually inspect for proper formation and clarity								
	Visually and inspect magic eye								
	Verified by: <u>Dh</u>								
160	HAND FINISHING THERMOFORMING	0.00							DAS 07 9-89
160	Memo	0.00				x/			14/09/17
HandThermo	1) Trim off excess flange material								
Hand Finishing Thermoforming	2) Buff out any light scratches or blemishes								
	3) Etch part number and batch number								

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC2- Inspect parts off machine FAI/FAIB	0.00							DAS 07 9-89
170						87			
QC	Memo	0.00							
Quality Control	1) Visually inspect for clarity, and proper formation.								14/09/17
180	QC5- Inspect part completeness to step on W/O	0.00							
180						1			Smp 14/9/17
QC	Memo	0.00							
Quality Control	1) Visually inspect for clarity, and proper formation.								
185	QC4- 100% Inspect kits for completeness	0.00							
185									DAS 06 9-89
QC	Memo	0.00							
Quality Control						17 2014			

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Revision ID: Stop ***NS2***
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Required Date: 6/04/14 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: _____	0.00		DAS					
190				06					
Packaging	Memo	0.00		9-89					
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

SEP 17 2014

MLJ 14-09-17

MF 14-9-19

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

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Work Order ID: 120381

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Parent Item: D412-711-101

D412-711-101

Parent Item Name: Replacement Vertical Reference Window

Start Date: 6/04/14

Required Date: 6/04/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 06-02-01 JLM
Manufacture in-house 10/06/28 DL

IPP Rev. B.

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRLICS.236		Purchased					sf	386.6600		22			

MACRLICS 236

Plexiglass G 60" x 96"x .236"

Location

Loc Qty

Loc Code

therm

386.66

M127669

38.66

M127867

92

M128747

256

Yl
14/09/17

22.7 *AK*

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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DART AEROSPACE LTD		Work Order: 120381
Description: Replacement Window		Part Number: D412-711-101
Inspection Dwg: D412-711-101 Rev: B		Page 1 of 1

**FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION**

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

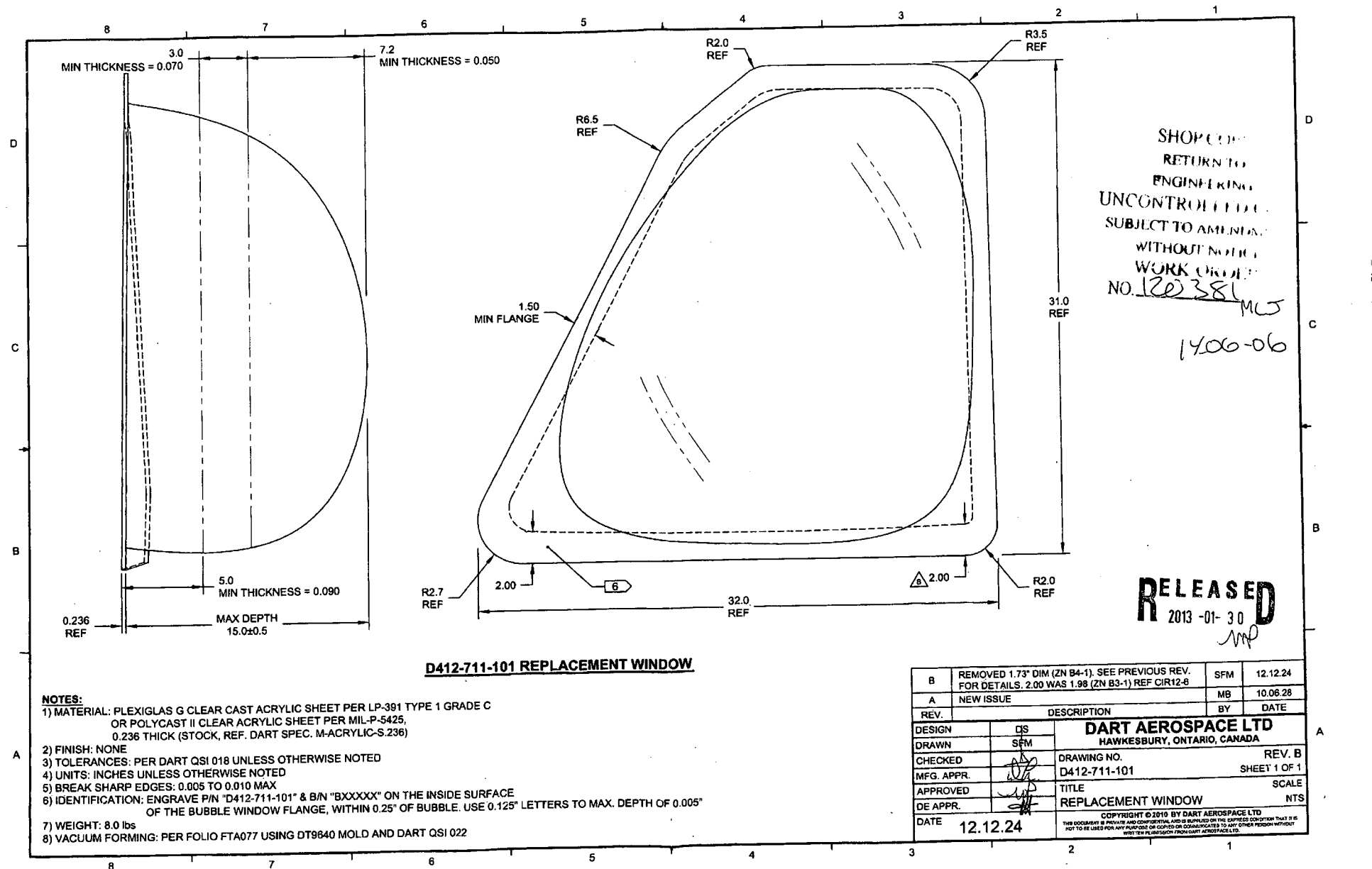
Measured by: <u>DAS 07</u>	Date: <u>14/09/17</u>
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.00	+/-0.030	<u>2.00"</u>	✓			
<u>N/A</u> 1.08	+/-0.030					
1.50	Min	<u>1.50"</u>	✓			
0.090	Min	<u>0.096"</u>	✓			
0.070	Min	<u>0.082"</u>	✓			
0.050	Min	<u>0.071"</u>	✓			
15.0	+/-0.5	<u>15.0"</u>	✓			

Measured by: <u>DAS 07</u>	Date: <u>14/09/17</u>
Audited by: <u>[Signature]</u>	Date: <u>[Signature]</u>
Preliminary Approval: <u>[Signature]</u>	Date: <u> </u>

Rev	Date	Change	Revised by	Approved
B	10.10.08	New Issue	KJ	[Signature]
C	13.06.03	Dimensions updated per Dwg Rev B	KJ	[Signature]



SHOP DRAWING
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 120381 ML
1406-06

RELEASED
2013-01-30